

5/16

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	22811
<b>Description:</b> 206 L/L-1/L-3/L-4 High Gear Web		<b>Part Number:</b>	D2654-7
<b>Drawing:</b> D2654 Rev. <i>04.08.17 kg 04.08.17 qf</i> <del>DEI</del>		<b>Qty:</b>	<i>6</i>

Step	Location	Procedure	By	Date	
1	EXPEDITING	Issue Work Order	KD	05/03/28	<i>271</i> <i>6</i>
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 .Web <i>B21130</i>	BE	05/04/14	<i>6</i>
3	METAL	Cut D2600-7 to length as per Dwg D2654 <del>(116.00)</del> <i>04.08.17</i>	BE	05/04/14	<i>6</i>
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	BE	05/04/14	<i>6</i>
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	BE	05/04/14	<i>6</i>
6	METAL	Deburr holes and ends	BE	05/04/14	<i>6</i>
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	BE	05/04/14	<i>6</i>
8	QC	Inspect Level 5	<i>Z</i>	05.04.14	<i>6</i>
9	METAL	Identify and stock	<i>DP</i>	05/4/14	<i>6</i>
10	EXPEDITING	Close Work Order Cost/part: <i>38.45 545 05/04/19</i> <i>91.09</i> <i>6</i>	<i>JA</i>	05.04.19	<i>6</i>

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	<i>(S)</i>

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

**RELEASED**  
*DM 99.02.19*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

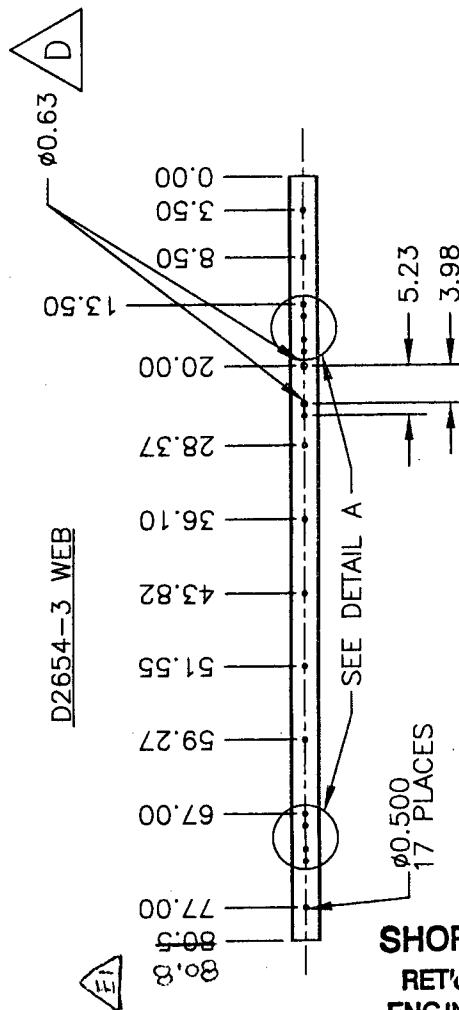
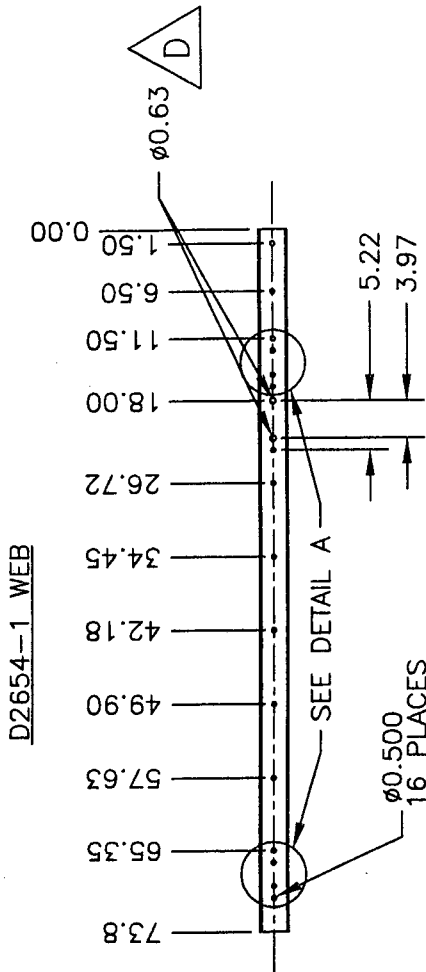
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE	04.05.26			TITLE	SCALE
				WEB	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	CP # 04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED  
04.06.22



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WORK ORDER

NO. 22811

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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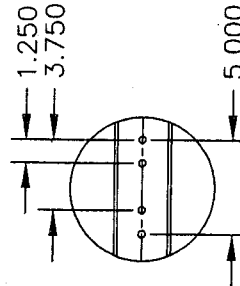
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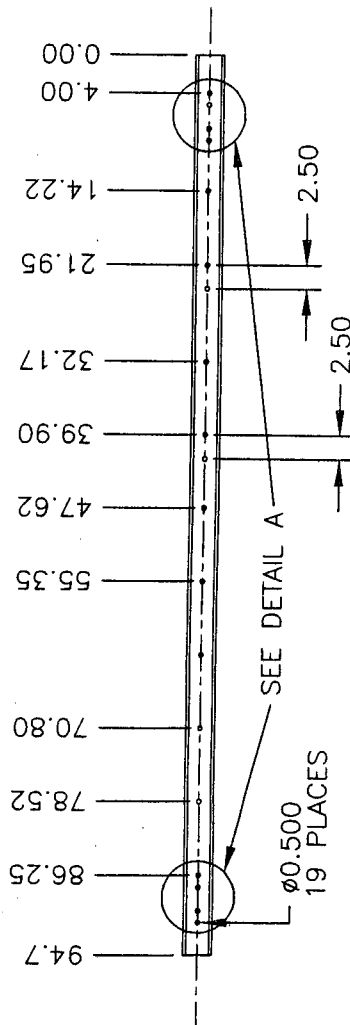
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED  
04.06.22

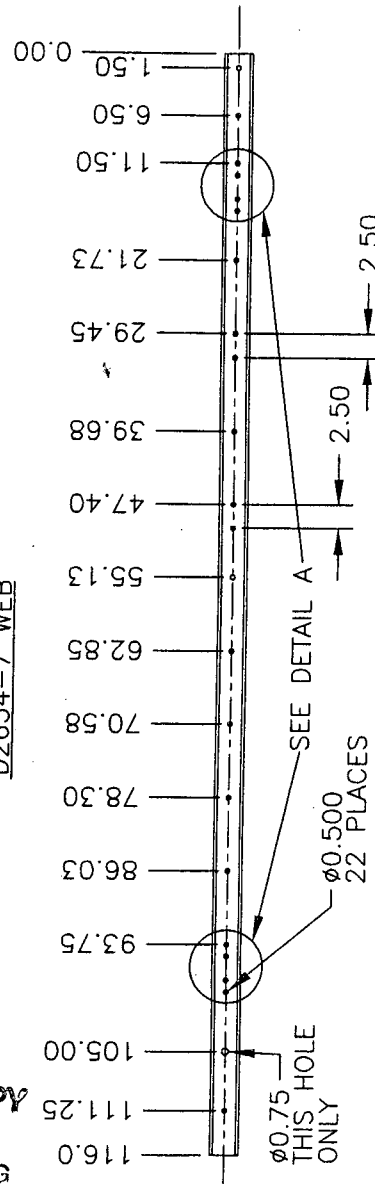
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Mar 23, 2005  
07:09 am

Work Order No	: 0022811	Department Code:	
Project Name	: D2654-7	Burden Flags	: NNNNNNNN
Project For	: WK516	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2654-7	Invoice Number	:
Description	: 206 I Beam (Web)	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 6	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 03-22-05		
Est Finish Date	: 04-22-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
=====					
Burden	0.00	0.00	0.00		
=====					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00